

New claim program, Gerfast 10/706,416

Claims.

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1. (cancelled) Butt-joining method comprising:

In two abutting metal strips punching a substantially rectangular slot into both abutments,
5 inserting into said two slots a deformable slug, clinching said slug into said slots,
thereby securely joining said strips.

2. (cancelled) Butt-joining method as defined in claim 1 wherein said slots
in both said abutments are keystone shaped instead of rectangular.

3. (cancelled) Butt-joining method as defined in claim 1 wherein said slots
10 in both said abutments have two rounded edges produced by both a punch and a die.

4. (cancelled) Butt-joining method as defined in claim 1 wherein said strips
are of other material than metal.

5. (cancelled) Butt-joining method as defined in claim 1 wherein a plurality of slots are used.

6. (cancelled) (Replaced by claim 15) Butt-joining method as defined in claim 2 wherein
15 said keystone shaped slugs slots are also having said rounded corners.

7. (currently amended) Butt-joining clinch method comprising:

In two abutting metal strips punching a substantially rectangular slot into both abutments,
wherein said slots have two rounded edges produced by both a punch and a die,
using one knock-out-slug from said punching, re-inserting said slug into the center of both
20 said abutments, clinching said slug into said slots thereby securely butt-joining said strips.

8. (cancelled) Butt-joining clinch method as defined in claim 7 wherein said slots
in both said abutments is keystone shaped instead of rectangular.

9. (cancelled) Butt-joining clinch method as defined in claim 7 wherein said slots
in both said abutments have two rounded edges produced by both a punch and a die.

- 25 10. (currently amended) Butt-joining clinch method as defined in claim 7 wherein said
strips are of other material then than metal.

11. (currently amended) Butt-joining clinch method as defined in claim 15 wherein a plurality of slots is used.
12. (previously amended) Butt-joining clinch method as defined in claim 7 wherein clinching height produced by said clinching is flush or slightly below 5 the surface of said strips.
13. (previously amended) Butt-joining clinch method as defined in claim 7 wherein said metal strips are mitered at 45 degrees and abutted at said mitering, with four said mitered strips forming a frame.
14. (currently amended) Butt-joining clinch method as defined in claim 13 wherein /O during said mitering remnants of said metal strips is purposely left at 45 degrees.
15. (Replaces claim 6) (currently amended) Butt-joining method comprising:
In two abutting metal strips punching a substantially keystone shaped slot into both abutments, wherein said slots have two rounded edges produced by both a punch and a die, inserting into said two slots a deformable slug, clinching said slug into said slots, 15 thereby securely butt-joining said strips.